

Date: Monday, 16/06/2008 10:25:16 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STRUT
Job Number :	39882		
Estimate Number :	10953		
P.O. Number :		Part Number :	D2562011
This Issue :	16/06/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2562 REV D
First Issue :	/ /	Project Number :	N/A
Previous Run :	28787	Drawing Revision :	D
	Type :	Material :	
	SMALL /MED FAB	Due Date :	30/06/2008
Written By :		Qty:	12 Um: Each
Checked & Approved By :	JUL 08.6.14		
Comment :	Est A 05.05.18 New Issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 2.3231 f(s)/Unit Total: 27.8775 f(s)
 304/316/318-2B Seamless Tubing, 1/2" O.D. x 0.035" wall
 Batch M108250

SB 08/06/17 (12)

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Punch to length as per Dwg D2562

SB 08/06/17 (12)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL/MED FAB RESOURCE
 1- Bend end as per Dwg D2562 Angle "D"
 2- Deburr

D 08/06/23 (12)
DM 08/06/23 (12)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08/06/23 (+12)

5.0	POWDER COATING	POWDER COATING
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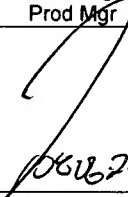
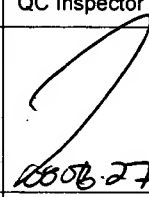


Comment: POWDER COATING
 Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME: 10:30 AM
 OVEN TEMPERATURE: 400°F
 FINISH TIME: 11:00 AM

PTO →
08/06/23 (12)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
0806-27	5.0	RECOAT MISSING PAINT START TIME 11:45 TIME 12:00 FINISH TIME 12:15	BR	0806-27	12	 0806-27	 0806-27	

Part No: _____ PAR #: _____ Fault Category: Prod / Finishing NCR: Yes (No) DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 16/06/2008 10:25:16 AM
User: Julie Lecocq

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 39882

Part Number: D2562011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



12X

Comment: INSPECT POWDER COAT

8/6/27

SD

7.0

PACKAGING 1

PACKAGING RESOURCE #1



12X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 264

8/6/27

SD

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/01

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-06-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

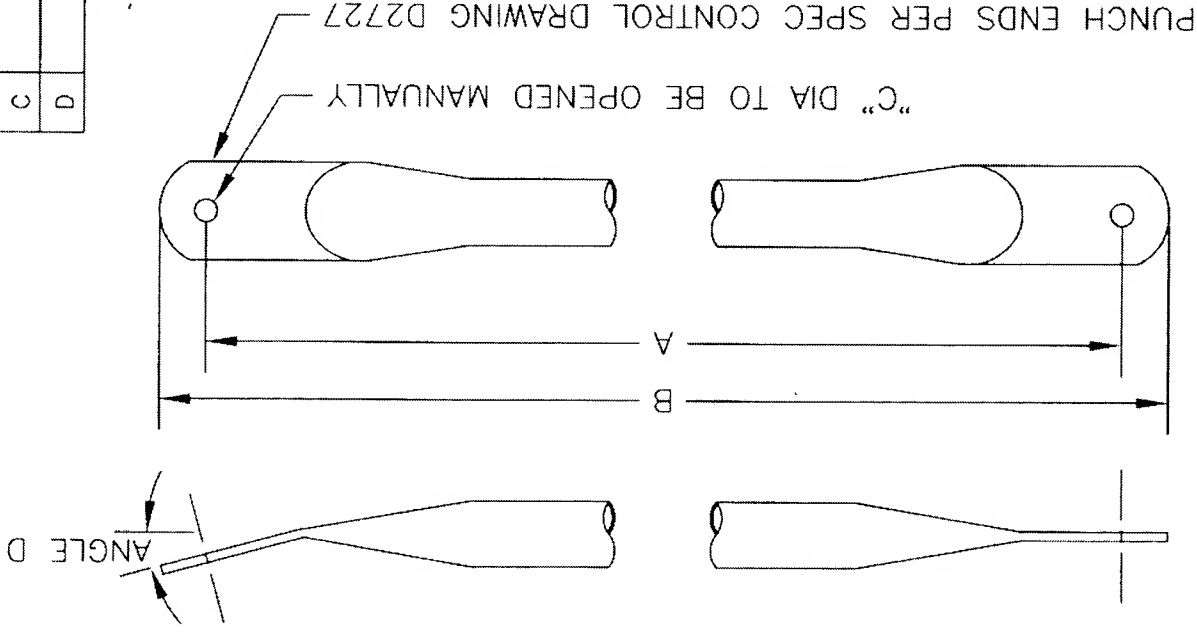
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD	
CP	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
		D2562	SHEET 1 OF 1
DATE	TITLE		SCALE
05.05.18	STRUT		1:2
A	96.05.01	NEW ISSUE	
B	98.10.15	UPDATED MATERIAL NOTE (TSR A603)	
C	02.06.05	ADD -005; ADD FINISH	
D	05.05.18	ADD -007/-011/-013; UPDATE -005	



- GENERAL NOTES
- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TRO.500W.035)
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART OSI 005 4.3
 - 3) TOLERANCES PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) ALL DIMENSIONS ARE IN INCHES

PART #	D2562-001	19.68	20.48	-	10	18	30	0									
DIM A	D2562-003	20.37	21.17	-	18	30	0										
DIM B	D2562-005	29.00	29.80	-	30	0											
DIM A	D2562-007	19.22	20.02	-	0												
D2562-011	D2562-013	25.79	26.59	-	16	24											

SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 21882

RELEASED
05.05.27

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